<b>Work Orde</b> <i>May-28-13 8:43</i>		02355		*102	2355*						Page 1	•
Revision ID:	D4093-5 Bracket			Accept	*N900	<b>040</b>	100	)* s	etup Star Stop	1 11	S1*	
Start Date: Required Date: Reference:	5/27/13 5/27/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:						•
Approvals:		lan: MLJ			Da	nte:		R	tun Star Stop	1/1	R1* R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Re	evision Nbr								· · · · · · · · · · · · · · · · · · ·		
D4093	', D											
100				0.00								
*100* Waterjet FLOW CNC Waterje	et	Memo CUT AS PEI DWG REV: PROG REV: DEBURR	D	0.00				6			Ae_ 13.06	·29
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							4	
*11 <b>0</b> *		Memo		0.00				6	O	/ /	Ae 13.06	. <del>2</del> 9

Quality Control

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	O	VFOR	MANCE / UP	DATE			
										QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part No.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR No.					Work Order Update			Large Fab	Composite		Supplier	
		<del></del>			l .		<u> </u>	·				
Root				Descri	ption of work order update		Initial	1	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		1										
Equip/Tooling												
Operator										<u> </u> 		
Material												
Setup												
Other	] ^										·	
Process												

		F	AU	LT CATEGORY		
Landing	Gear	General		_	_	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Г	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		 
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish	Г	Out of Sequence		

Outside Dimensions

Wave/Twist in Tube

Folio

Supplier Training Unapproved

Work Order ID 10235  May-28-13 8:43:03 AM		)2355		*102	2355*		*102355*							
Item ID: Revision ID: Item Name:	D4093-5 Bracket			Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop	*N *N	S1* S2*		
Start Date: Required Date: Reference:	5/27/13 : 5/27/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:								
Approvals:	Process Pl QC:	lan:	Date:			ate:			Run	Start Stop	*N *N	R1* R2*		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp		
*120 *120* QC Quality Control		QC8- Inspect parts - sec	ond check	0.00				<b>(</b>	13-1	<u>0</u> 3-0	) <u>C</u>	045 09 		
*130 *130* Small Fab Small Fab		<b>Memo</b> C' SINK AS	S PER DWG	0.00				6x		<del></del>		<u> </u>		
140		QC5- Inspect part comp	leteness to step on W/O	0.00										

0.00 16 13/07/02

\*14**0**\*

Quality Control

Memo

											DQA:	Da	ite:	
NCR: \	es/	/ No				WORK ORDER NON-C	OI	NFORM	MANCE / UPDATE		QA Closed:	Da	ate:	
						DISDOSITION			ACAINST					
Work Orde	er:					DISPOSITION	_		AGAINSI		PARTMENT, -	PROCESS		
Part N	No.					Rework Scrap		1	Skid-tube Crosstube  Machining Small Fab			Water Jet d. Eng. Coor.		Engineering Quality
NCR I	No.					Use-as-is Work Order Update	]	li .	noforming Finishing Large Fab Composite	-	Rec/stor	e/Packaging Supplier	-	Other
Root					Descri	ption of work order update	ı	Initial	Action		Sign &			
Cause	$\Box$	Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data														·
Equip/Tooling	Ш													·
Operator	Ш													
Material														
Setup	ے													
Other														
Process	Ш													
Supplier														
Training	$\square$													
Unapproved	Ш		<u> </u>											
						F	AUL	LT CATE	GORY					
Landi	ng G	ear			_	General	_	_			•		_	•
	Ш	Bending				Bend	$\Box$	Grain		L	Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire	L	Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete	L	Part Incorred	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved			
		Heat Trea	ıt			Countersink		Mislahe	alad		Dositioned M	drong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

<b>Work Ordo</b> <i>May-28-13 8:43</i>		02355		*102	2355*					Page 3
Item ID: Revision ID:	D4093-5			Accept	*N900	<b>040</b>	100	)* s	Setup Start	ועיטו
Item Name:	Bracket								Stop	*NS2*
Start Date: Required Date: Reference:	5/27/13 5/27/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:				
Approvals:	Process P	Plan:	Date:	Tooling:	D <sub>2</sub>	ıte:	**	F	Run Start	*NR1*
Approvais.		1411.	Date:			ite:			Stop	*NR2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	•	Reject Insp. Number Stamp
150		Chemical Conversion Co	oat per QS1005 4.1	0.00						- ·
*150* HandFinish Hand Finishing		Memo		0.00				6	26	13-7-5
<sup>160</sup> *1հՈ*		QC7-Inspect Chemical C	Conversion Coat	0.00 AS	lat i			(Va	<b>.</b>	
OC		Memo		0.00	19114				<i></i>	

180

\*120\* Packaging Packaging

Memo

0.00

0.00

Quality Control

Identify as per dwg & Stock Location: \$\frac{570}{93}\$

									DQA:	Dat	:e:
NCR: Ye	es / No			WORK ORDER NON-O	CON	IFORM	AANCE / UPD	DATE	QA Closed:	Dat	re:
Work Orde	r:			 DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N				Rework Scrap Use-as-is Work Order Update		M Therm	Skid-tube  Machining  noforming  Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	ption of work order update or Non-conformance		nitial ief Eng	Acti Descri		Sign & Date	Verification	n QC inspector
oc/Data quip/Tooling perator Material etup other rocess upplier training											
				<del></del>	AUL'	T CATE	GORY				
Landin	Bending Centre N Cracks Crushed Cuffs Heat Tre Inspecti Ripples Torque	Not Conce /Crimped eat on Strip ir	ı Tube Extrusio	General  Bend  BOM/Route  Broken/Damaged  Burrs  Contamination  Countersink  Cut Too Short  Drill Holes  Drawing  Finish		Instruct Mainte Mislabe Misread Offset Out of O	ion Incomplete tions Incomplete/U enance eled	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Ī	Wave/T	wist in Tu	be	Folio		Outside	Dimensions				

Work Order ID 102355  May-28-13 8:43:03 AM			*102355*										Page	e 4
Item ID: Revision ID: Item Name:	D4093-5 Bracket			-	Accept	*N900	<b>040</b>	100	)*	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	5/27/13 : 5/27/13	Start Qty: 6.00 Req'd Qty: 6.00		'6* '6*		Cust Item I Customer:	D:							
Approvals:	Process P	lan:	Date:				ate:			Run	Start Stop	*N *N	R1* R2*	•
Sequence ID/ Work Center I 190 *1 QC Quality Control	D	Operation Description QC21- Final Inspection - Memo	- Work Order R	elease	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep	t Re Qt	3/1	Reject Number 7/8	Insp. Stamp	)

NCR:	Yes	/	No
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DQA: \_\_\_\_ Date: \_\_\_\_

NCR: Ye	es / No				WORK ORDER NON-C	LONFO	JKIV	IANCE / UP		QA Closed:	Date	
<del></del>	·L:						•					•
Work Orde	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap		M	Skid-tube 1	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update			oforming arge Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initi	ial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(	or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling						İ						
Operator												
Material		}										
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Other												
Process												
Supplier												
Training						1						
Unapproved		<u> </u>				1						
					F	<b>AULT C</b>	ATEG	ORY				
Landin	g Gear			·	General					•	_	_
_	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
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	Cracks				Broken/Damaged	Ins	pectio	on Incomplete		Part Incorre	ct _	Weld
	Crushed/	Crimped			Burrs	Ins	tructio	ons incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mā	ainter	nance		Part Moved		
	Heat Trea	at .			Countersink	Mis	slabel	ed		Positioned V	Wrong _	_
	Inspectio	n Strip in	Tube		Cut Too Short	∐_Mis	sread			Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes	Off	fset					
	Torque W	/aves in E	xtrusion	ı [	Drawing	Ou	it of Ca	alibration				
	Turning S	equence			Finish	Ou	it of Se	equence				
[	Wave/Tw	ist in Tul	эе		Folio	Ou	itside	Dimensions				

Page 1

Work Order ID:

102355

Parent Item:

D4093-5

Parent Item Name:

Bracket

**Start Date:** 5/27/13

Required Date: 5/27/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-10-01 ILM VERIFIED BY:DD

Comments:	IFF KEV.A NEW	1330E 10-10-01	JEIVI VE	U. 10 01.0	·								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.188 6061-T6 .188 Sheet		Purchased	No			100	sf	56.7500	0.025	0.1578948	Ae	/3·c	s6.29

<b>Location</b>	Loc Qty	Loc Code	
MAT021	56.75		
124572_	56.75		0.16

											DQA:	Date:	:
NCR:	Yes	/ No				WORK ORDER NON-	COf	NFORM	/IANCE / UP	DATE			
								•			QA Closed:	Date:	-
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Old	C1.					Rework	7		Skid-tube	Crosstube	1	Water Jet	Engineering
Part	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			<del>.</del>			Use-as-is	1	1	noforming	Finishing	-4	re/Packaging	Other
NCR	No.					Work Order Update	1		Large Fab	Composite	1,	Supplier	1
							لہ				_		
Root					Descri	ption of work order update		Initial	Ad	ction	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data	L												
Equip/Tooling	L						1						
Operator			ļ				1						
Material								:					
Setup													
Other							1						
Process							ŀ						
Supplier													
Training	L												
Unapproved													
						F	AUI	LT CATE	GORY				
Land	ing (	Gear			_	General		-		_	_		<b>-</b>
		Bending				Bend		Grain		L	Ovalized	L	Pressure/Forced
		Centre N	ot Conce	ntric to (	o/s	BOM/Route		Hardware			Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
		Crushed/	'Crimped			Burrs		Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
	L	Heat Tre	at			Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short	Г	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	105322
Description: Bracket	, Part Number:	D4093-5
. 1		
Inspection Dwg: D4093 Rev:		Page 1 of 1

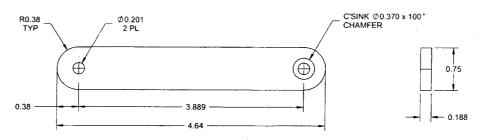
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of inspection	Comments
Ø0.201	+0.005/-0.001	.203	-		V	UKM-01
0.38	+/-0.030	- 38	_		# RG	
0.75	+/-0.030	.75			V	
4.64	+/-0.030	4.64	-		V	
3.889	+/-0.010	4.64 3.889			V	UKM-01
0.188	+/-0.010	.187	-		V	
0.080	+0.005/0.001					
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Measured by:	Ae	Audited by:	DAS	Preliminary Approval:	
Date:	13.06.29	Date:	ふるかり	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.10.07	New Issue	KJ	
В	11.07.26	Dwg Rev updated	KJ 1	<b>N N</b>
С	13.05.08	Dimensions updated per Dwg Rev C	KJ 🔀	X
			777	

<b>P</b>	公司是一个人,我们们也是一个人,我们们也没有一个人,不是一个人,我们们也没有一个人,我们们也没有一个人,我们们也没有一个人,我们们也没有一个人,我们们也没有一个		100
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 $\langle F \rangle$ 102353 MCJ 13-05-29

TOPY ordent.

## D4093-5 BRACKET

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
OR 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M606176B/M606176S
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE 7) WEIGHT: 0.06 lbs

D

DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN RF		KENT, WA		
CHECKED	15	DRAWING NO.	REV. D	
MFG. APPR.	A.F.	D4093	SHEET 5 OF 5	
APPROVED	d.	TITLE	SCALE	
DE APPR.		BRACKET	NTS	
DATE 12.0	9.18	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CORFORMAL AND IS SUPPLIED ON THE EXPRESS CONCITION THAT IT IS		

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